

Work Order ID 69013

Wednesday, April 27, 2011 10:12:09 AM



Page 1

Item ID: D4018-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib

Start Date: 4/27/2011 Start Qty: 18.00



Cust Item ID:

Required Date: 5/3/2011 Req'd Qty: 18.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

[Signature]

Date: 11-04-27

Tooling:

Date:

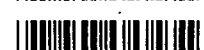
QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4018	C								

100

0.00



Large Fab

Memo

0.00

Large Fab

1- Cut tube as per dwg D4018
2- debur and remove identification markings

SAD

11-05-10

23

110

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

QC 11-05-11

120

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

QC 11-05-11

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Cust Item ID:

Required Date: 5/3/2011 Req'd Qty: 18.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

4/5/11 [Signature]
NMC
11-05-11

W/O:		WORK ORDER CHANGES						
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Picklist Print

Wednesday, April 27, 2011 10:12:16 AM

Page 1

Work Order ID: 69013



Parent Item: D4018-5



Parent Item Name: Rib

Start Date: 4/27/2011

Required Date: 5/3/2011

Start Qty: 18.00

Required Qty: 18.00

Comments: IPP RevA: new issue DD 09.11.26 verified by:EC IPP Rev:B as
per dwg revA 10.03.15 verified by:EC IPP Rev:C as per dwg
RevB DD 10.04.16 verified by:EC IPP Rev:D as per dwg revC DD
10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TS0.500W.049 Square Tubing		Purchased	No			100	f	99.8153	0.5558	10.53095 13.4563 SAD 11-05-10			
			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>						
			MAT034		99.8153								
			116610		0.8383								
			117314		98.977				13.4563				

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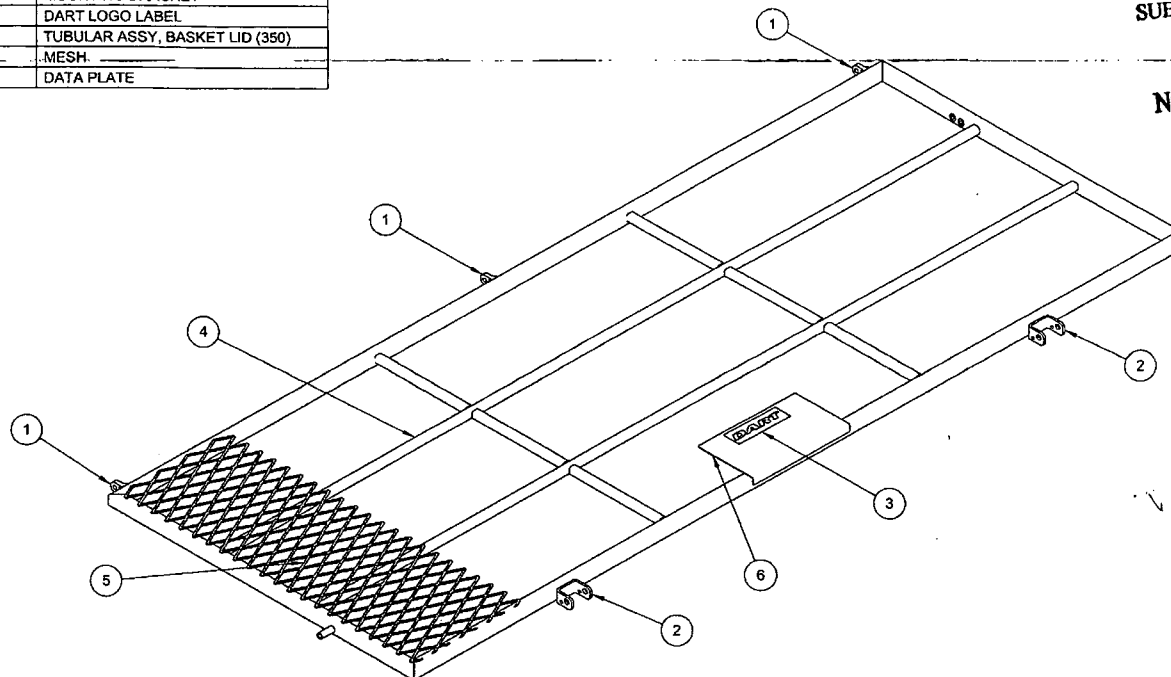
NOTE: Date & initial all entries

SHOP COPY

RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69013

PL 11-04-27

ITEM	QTY	P/N	DESCRIPTION
	X	D4018-041	SHORT BASKET LID ASSY (350)
1	3	D4016-3	HINGE HALF, LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	1	D4018-101	TUBULAR ASSY, BASKET LID (350)
5	1	D4020-7	MESH
6	1	D4021-3	DATA PLATE



D4018-041 SHORT BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.05
ECN 10-916

C	REMOVED D4088-232, UPDATED DETAIL E ACCORDINGLY (C8-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
B	BOM: INSERTED QTY 1 D2728-3 AS ITEM 3 & QTY 1 D4088-232 PLACARD AS ITEM 7. ITEMS RENUMBERED AS REQD. SHEET 2, NOTES: PAINT SPEC ADDED & NOTE 7 & 8 REVISED. (B4-2) FRONT VIEW ADDED, WELDING SYMBOLS REVISED. DETAIL VIEW E ADDED (C4-2)(C82). SIDE VIEWS ADDED (C1-4)(D1-4).	JPH	10.03.25
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>ALS</i>		
DRAWN			
CHECKED	<i>SC</i>		
MFG. APPR.	<i>MP</i>		
APPROVED	<i>MP</i>		
DE APPR.	<i>MP</i>		
DATE	10.08.05		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. C
D4018 SHEET 1 OF 4
TITLE SCALE
SHORT BASKET LID ASSY (350) NTS

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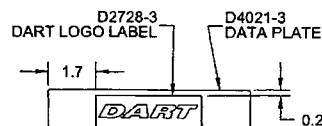
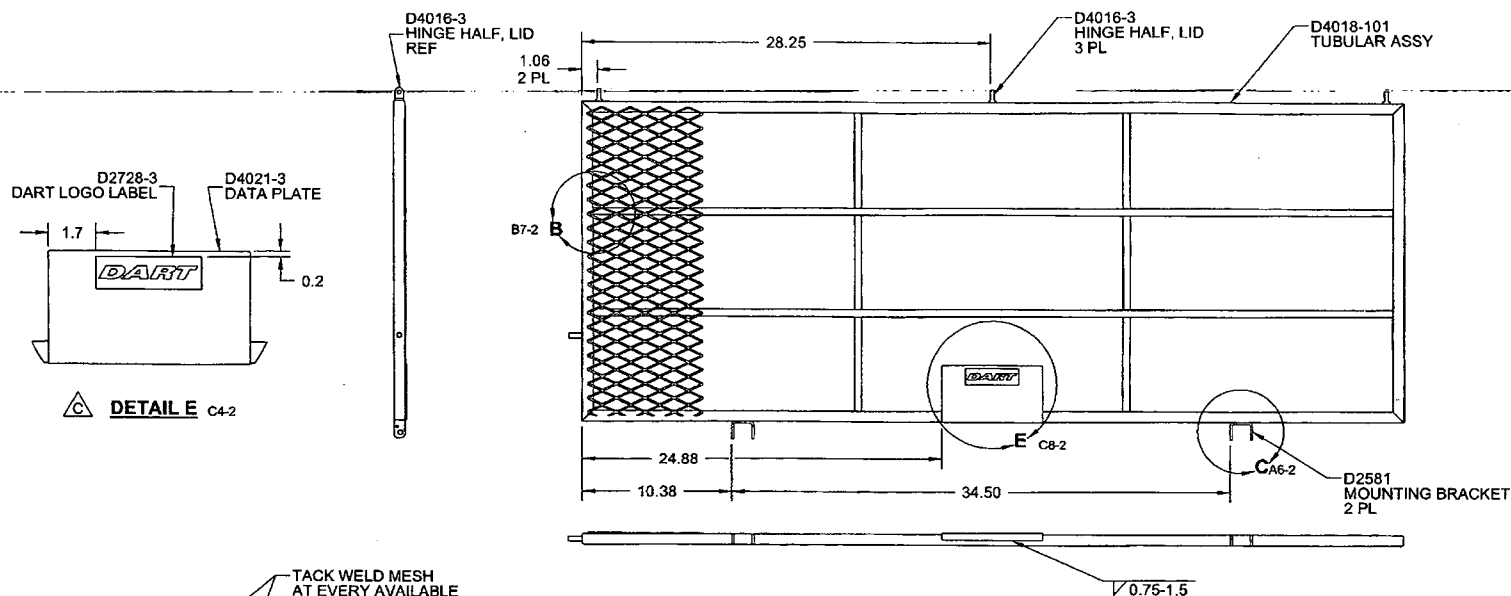
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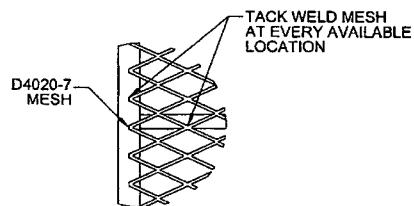
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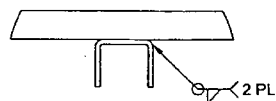
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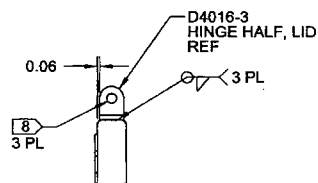
DETAIL E C4-2



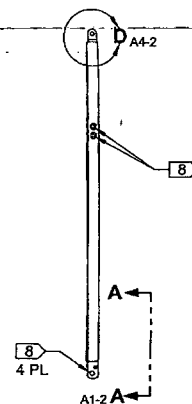
DETAIL B C6-2



DETAIL C C3-2



DETAIL D D1-2



VIEW A-A C1-2

D4018-041 SHORT BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.5 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004

DESIGN	ALS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC	DRAWING NO. D4018	REV. C
CHECKED	SC	SHEET 2 OF 4	
MFG. APPR.	WJ	TITLE	SCALE
APPROVED	WJ	SHORT BASKET LID ASSY (350)	NTS
DE APPR.	WJ	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS RECOGNITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR DISCLOSED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	10.08.05		

u/b 69013

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

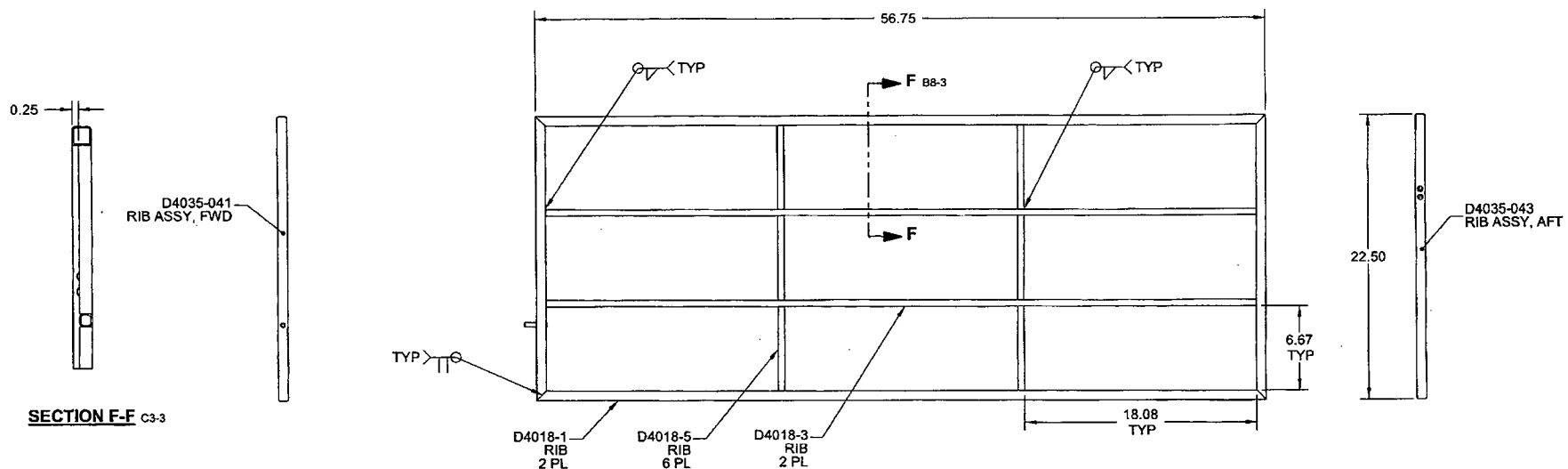
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NOTE: Date & initial all entries

ITEM	QTY -101	P/N	DESCRIPTION
	X	D4018-101	TUBULAR ASSY, BASKET LID (350)
1	2	D4018-1	RIB
2	2	D4018-3	RIB
3	6	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



8 D4018-101 TUBULAR ASSY, BASKET LID (350)

RELEASED
10.08.12 LP

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. C
MFG. APPR.	SC	D4018	SHEET 3 OF 4
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	SHORT BASKET LID ASSY (350)	NTS
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- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 9.06 lbs
 - 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
 - 9) WELD PER DART QSI 004

W/O:		WORK ORDER CHANGES						
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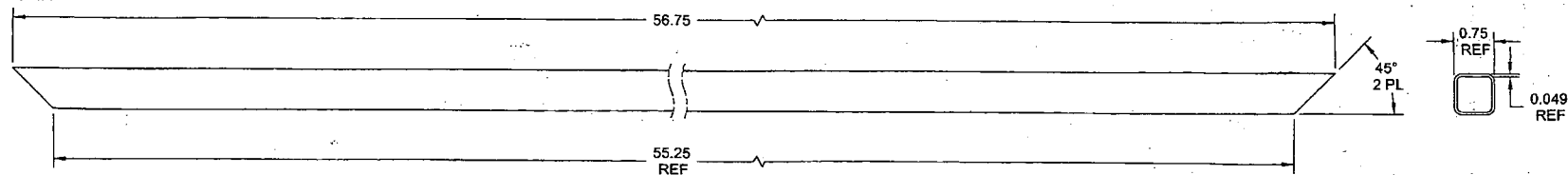
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8 7 6 5 4 3 2 1

D

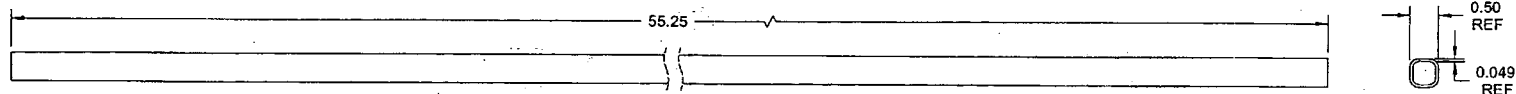
D



D4018-1 RIB

C

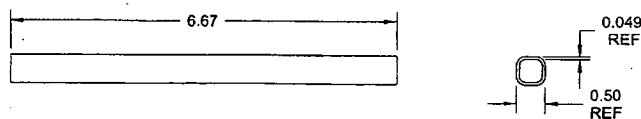
C



D4018-3 RIB

B

B



D4018-5 RIB

u/b 69013

RELEASED
10.08.05

NOTES:

1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-3 & -5: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	ISC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ISC	DRAWING NO.	REV. C
MFG. APPR.	ISC	D4018	SHEET 4 OF 4
APPROVED	ISC	TITLE	SCALE
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8 7 6 5 4 3 2 1

A

A

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